



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

K10003
Job Sheet 170023



Part No: K10003

Job Qty: 5 ea

Part Name: Saddles



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV H IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF IPP : J 06-07-25 As per DSI 9344
JLM IPP : K 06.11.17 Per K10003 Rev C KJ IPP : L 07.01.12 Document Record for copying bluefile rmv KJ
IPP Rev: M 08-08-12 now @ chg 006 (DSI 9418) DD verified: IPP N 09.01.27 DSI 9418 rev B EC verified: DD
IPP Rev: O 11.03.11 per dsi9536 DD ver: EC IPP REV: P 12.01.23 AS PER ECN11-684 VER: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	1/19/18	1/19/18	0.00	0.00	Start Up Stores/Pkg-1	5/2	FEB 01 2018 W.K.
110	Packaging	5 pcs	1/19/18	1/19/18	0.00	0.00	Packaging1-5	5/2	
120	QC	5 pcs	1/19/18	1/19/18	0.00	0.00	QC4		SmB
125	DC	5 pcs	1/19/18	1/19/18	0.00	0.00	DC		
130	Packaging	5 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-2		SmB
140	QC21-FG	5 Ea	1/19/18	1/19/18	0.00	0.00	QC21		DAB 21 FEB 09 2018 fg 129

Part Op Descriptions: 125 - Create White labels only per PPP K10003 CHG 0010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN4-51A	40	172	0	0
	AN4-6A	80	631	0	0
	AN4C46A	20	305	0	0
	AN6-12A	40	217	0	0
	D2570	120	132	0	0
	D2571	5	13	0	0
	D2572	5	11	0	0
	D2573	5	18	0	0
	D2574	5	13	0	0
	D2747	20	128	0	0
	D2876	10	57	0	0
	D2877	10	46	0	0
	D3405-041	5	38	0	0
	D3405-043	5	28	0	0
	D3407-041	5	9	0	0
	D3417-5	10	74	0	0
	D3456-1	5	134	0	0
	D3533-1	10	81	0	0
	MS21042L4	120	3,678	0	0
	MS21043-4	25	1,261	0	0
	NAS1149D0463J	160	5,737	0	0
	NAS1149D0663J	40	1,371	0	0

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

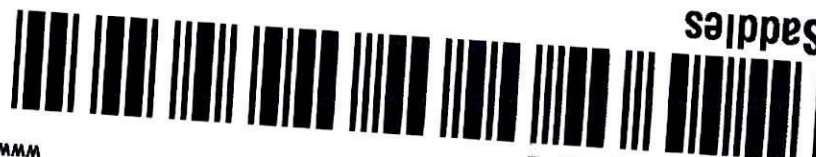
Job No: 170023
Start up Operation 02/07/18

Change No: _____
Operation: _____
Revision: _____
Original Serial #: S040017
PART NO: K10003

Completed By _____

Ind / Supervisor
Val Verification

QA Coordinator
Approval



Saddles

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CANADA
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Root Cause			Symptoms			DART AEROSPACE S040017			Disposition		
Environment ☐	No Re-verification ☐	Pressure ☐	Contamination ☐	Off-set ☐	Drawing ☐	Positioned Wrong	Environment ☐	Operator ☐	Bending ☐	Countersink ☐	tside Dimensions
Design ☐	Offset/Setup ☐	Centre ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	er/Under tolerance	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Instructions Incomplete/Unclear ☐	rt Incorrect
Handling/Pre ☐	Training ☐	Crimp/Kink/Kippie ☐	Drill Holes ☐	Fit/Function ☐	Misread ☐	rt Lost/Missing	Material ☐	Use for Testing ☐	Cuffs ☐	Misaligned/off center ☐	rt Moved
Internal Transport ☐	Poor Information ☐	Crushing ☐			Turning Sequence ☐		Tribal Knowledge ☐	Use for Testing ☐	Heat Treat ☐		
LOA ☐	Rushing ☐	Wave/Twist in Tube ☐					Substation ☐	Product Improvement ☐	Marks/Chatter ☐		
Past Expiry Date ☐	Process Improvement ☐						Misidentified ☐	Manufacturing Process ☐			
	Past Due ☐								OTHER : ☐		



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Master Unit 000301

Tel (613) 632-5200

Containers on Master Unit 000301				
Serial No	Part No	Customer Part No	Status	Quantity
S037746	AN4-51A		Allocated	40
S037732	AN4-6A	AN4-6A	Allocated	80
S037729	AN4C46A	AN4C46A	Allocated	20
S037727	AN6-12A		Allocated	40
S037720	D2570	D2570	Allocated	120
F163785	D2571		Allocated	4
S037718	D2571		Allocated	1
F163484	D2572		Allocated	1
S002179	D2572		Allocated	4
S037656	D2573	D2573	Allocated	5
F158743	D2574	D2574	Allocated	3
S037653	D2574	D2574	Allocated	2
S037651	D2747		Allocated	20
S037647	D2876		Allocated	10
S037641	D2877		Allocated	10
S037639	D3405-041		Allocated	5
S033126	D3405-043		Allocated	4
S037624	D3407-041		Allocated	5
S037622	D3417-5	D3417-5	Allocated	10
S037320	D3456-1	D3456-1	Allocated	5
S037319	D3533-1		Allocated	10
S037310	MS21042L4	MS21042L4	Allocated	120
S037309	MS21043-4	MS21043-4	Allocated	25
S037306	NAS1149D0463J	NAS1149D0463J	Allocated	160
S037303	NAS1149D0663J		Allocated	40

D3405-043 S040015 x1

Item	635 -111	635 -141	635 -143	641 -011	Part Number	Description
	X				D204-635-111	SKIDTUBE INSTALLATION WITH TRAINING WEARPLATE
	1	X			D204-635-141	REPLACEMENT SKIDTUBE WITH TRAINING WEARPLATE
			X		D204-635-143	TRAINING WEARPLATE KIT
	1			X	D205-641-011	GROUND HANDLING KIT
1		1			D2590-043	204 SKIDTUBE ASSEMBLY
2A		4			D2594-1	* PLUG
2B		4			D2594-3	* O-RING
3		1			D2855	* AFT CAP
4		2			AN3-5A	* BOLT
5		2			NAS1149D0332J	* WASHER (AN960JD10L)
13		2			ALS4-1032-225	* INSERT
14		1	1		D4408-041	* FWD WEARPLATE ASSEMBLY
15		1	1		D4408-043	* AFT WEARPLATE ASSEMBLY
16		8	8		AN4-45A	* BOLT
17		16	16		D2570	* BUSHING
18		8	8		MS21042L4	* NUT (OR MS21042-4)
19			4		D2579	* SPACER
20	1				D2571	SADDLE, FWD OUTSIDE
21	1				D2572	SADDLE, FWD INSIDE
22	1				D2573	SADDLE, AFT OUTSIDE
23	1				D2574	SADDLE, AFT INSIDE
24	8				AN4-51A	BOLT
25	16				D2570	BUSHING
26	8				MS21042L4	NUT (OR MS21042-4)
27	8				AN6-12A	BOLT
28	8				NAS1149D0668J	WASHER (AN960JD616)
29	16				AN4-6A	BOLT
30	32				NAS1149D0463J	WASHER (AN960JD416)
31	16				MS21042L4	NUT (OR MS21042-4)
32	4				D2747	SET SCREW
33	2				D3533-1	SET SCREW
40	1				D3407-041	TOW RING ASSEMBLY (REPLACES D2968-041)
41	1				D3456-1	WASHER
43	1				MS21043-4	NUT
44	2				D3417-5	WASHER
50				1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51				1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52				4	AN4C46A	BOLT
53				8	D2570	BUSHING
54				4	MS21043-4	NUT
60	2				D2876	SADDLE SPACER
61	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2590-043 ASSEMBLY ABOVE